

Work Order ID 83866

83866

Page 1

April-26-12 2:28:58 PM

Item ID: D3391-021

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Tube Assembly

Stop ***NS2***

Start Date: 26/04/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/26 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3391

1

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut extrusion to 46.52 +0.010 -0.020

DL 12/05/22

110

0.00

110

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391 Using Bend Prog 3391021

DL 12/05/31

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

6.88"

DP12-6-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3391-021

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Tube Assembly

Stop ***NS2***

Start Date: 26/04/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HAAS I HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA590 Rev <u>1</u> & Dwg D3391 Rev. <u>1</u> Identify as D3391-1 2-Deburr	0.00 0.00		2-6-3		1	4		
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		2-6-3		1	4		
150 *150* Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo Drill X1 Aft cap as per Dwg D3391 .1875" dia	0.00 0.00		12/06/05		1	4		

W/O:		WORK ORDER CHANGES					
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W/O:
 rt Aerospace Ltd

Item ID: D3391-021

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N900040100

Setup

Revision ID:

Item Name: Fwd Tube Assembly

Stop *NS2*

Start Date: 26/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00

160

QC

Memo

0.00

Quality Control

ent 12/06/05

170

QC8- Inspect parts - second check

0.00

170

QC

Memo

0.00

Quality Control

SA 12/6/5

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start *NS1*

Revision ID:

Item Name: Fwd Tube Assembly

Stop *NS2*

Start Date: 26/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

NO WEARPLATE HOLES ARE TRANSFER DRILLED

DC 12/06/12

DC 12/08/02

CF 12-8-2

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

DAS
16
9-83

17/06/03

Part Aerosol

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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WORK ORDER NON-CONFORMANCE (NCR)

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8.3866

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Item Name: Fwd Tube Assembly

Stop ***NS2***

Start Date: 26/04/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Chemical Conversion Coat per QSI005 4.1	0.00							
200									
HandFinish	Memo	0.00							
Hand Finishing									
210	QC7-Inspect Chemical Conversion Coat	0.00							
210									
QC	Memo	0.00							
Quality Control									
220		0.00							
220									
Skidtubes	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: <u>1120666</u> exp. date: <u>13-1-30</u> cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary								

1 26 12/08/08

1 BB 12/08/08

-DC 12/08/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3391-021
Revision ID:
Item Name: Fwd Tube Assembly

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N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 26/04/2012 Start Qty: 1.00 ***1***
Required Date: 26/04/2012 Req'd Qty: 1.00 ***1***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230 QC5- Inspect part completeness to step on W/O 0.00

230

QC Memo

Quality Control

DAS
16
2-03 12/08/12

235 Pressure Wash per QSI005 4.3 0.00

235

HandFinish Memo 0.00

Hand Finishing AND REALODINE AS PER PAR09-043

1 76 12-8-23

240 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

240

Powdercoat Memo 0.00

Powder Coating

START TIME: 8:10
OVEN TEMPERATURE: 320 OF
FINISH TIME: 8:40

1X-0 MF 12/08/23

m121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 83866

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83866

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Item ID: D3391-021

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Tube Assembly

Start Date: 26/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	QC3- Inspect Part Finish	0.00							
250									
QC	Memo	0.00				1x	1	12/08/23	
Quality Control									
255		0.00							
255	Skidtubes								
Skidtubes	Memo	0.00				1x	1	12/08/23	
Skidtubes	*** install D3591-1 spacer as per DSI9364 and wearplate as per DWG ***								
257	QC5- Inspect part completeness to step on W/O	0.00							
257									
QC	Memo	0.00							
Quality Control									



12/08/23

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 83866

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83866

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Item ID: D3391-021
Revision ID:
Item Name: Fwd Tube Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 26/04/2012 Start Qty: 1.00 ***1***
Required Date: 26/04/2012 Req'd Qty: 1.00 ***1***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location: <u>W10</u>	0.00	0412-442-043/13	87072					
260		0.00							
Packaging	Memo								
Packaging									
280	QC21- Final Inspection - Work Order Release	0.00							
280		0.00							
QC	Memo								
Quality Control									

OK 12/8/27
ME
12-08217

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

April-26-12 2:29:02 PM

Page 1

Work Order ID: 83866

83866

Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 26/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.09.13New issue KJ/JLM
 IPP B06.02.10Dwg rev.D ecn 773 EC
 IPP C06.05.02Added inspections EC
 IPP D 07.03.13 rev F dwg EC
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-051		Manufactured	No			255	Each	29.0000	1	1			

D4095-051

Wearpad Assembly

Location	Loc Qty	Loc Code
FP002	29	
78914	7	
81613	22	

D6013-047

Manufactured No

100

Each

102.0000

1

D6013-047

Skidtube Material

Location	Loc Qty	Loc Code
LG	102	
72505	102	

**

12/08/23

**

12/05/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

April-26-12 2:29:02 PM

Page 2

Work Order ID: 83866

83866

Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 26/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

220

Each

55.0000

4

4

D3670-4-200

SPACER

**

Dec 12/08/08

Location

B84504

Loc Qty

Loc Code

LG

40

80360

40

LG001

15

72851

3

78606

12

(2)

(2)

D3401-041

Manufactured No

255

Each

17.0000

1

1

D3401-041

Tow Cap Assembly

**

HL 12/08/27

Location

Loc Qty

Loc Code

FP002

17

78990

2

82302

15

X1

AN960C10L

NAS1149C0332

Purchased

No

255

Each

0.0000

10

10

*AN960C10I *

washer

**

HL 122063 (V10) HL 12/08/27

AN3C4A

Purchased

No

255

Each

1.915.000

10

10

AN3C4A

BOLT

**

HL 12/08/23

Location

Loc Qty

Loc Code

ST350

1915

120187

849

120521

28

120769

38

121205

1000

HL 122151

X10

April-26-12 2:29:02 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 26/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

255

Each

842.0000

4

4

D3672-1

Phenolic Washer

**

JH 12/08/23

Location

Loc Qty

Loc Code

ST060

842

72229

4

76277

338

80369

500

V4

AELS-1032-225

Purchased

No

255

Each

0.0000

10

10

AFI S-1032-225

✗ AHS7-1032-225 / 11122290

**

(x10) JH 11/08/23

INSERT

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Dart Aerospace Ltd

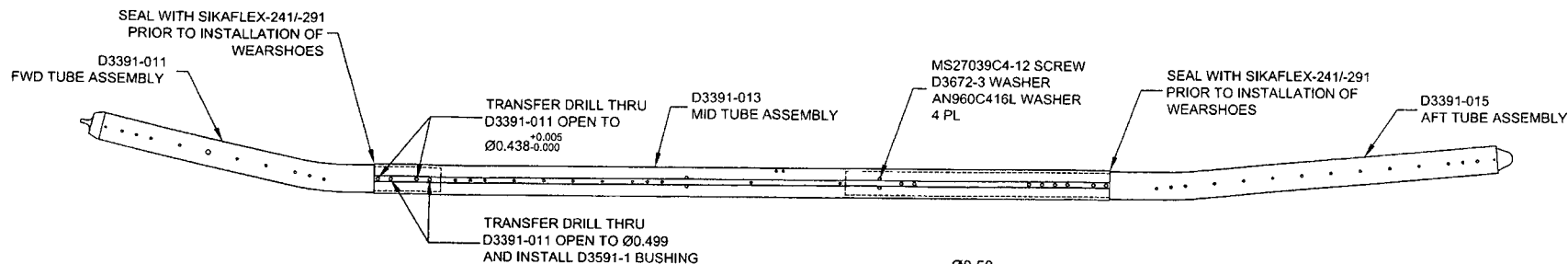
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83866 MLC
12/04/20

D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04
ECN# H-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.13		

DART AEROSPACE USA, INC
KENT, WA
DRAWING NO. **D3391** REV. **I**
SHEET 1 OF 8
TITLE **412 FLOAT SKIDTUBE** SCALE **NTS**
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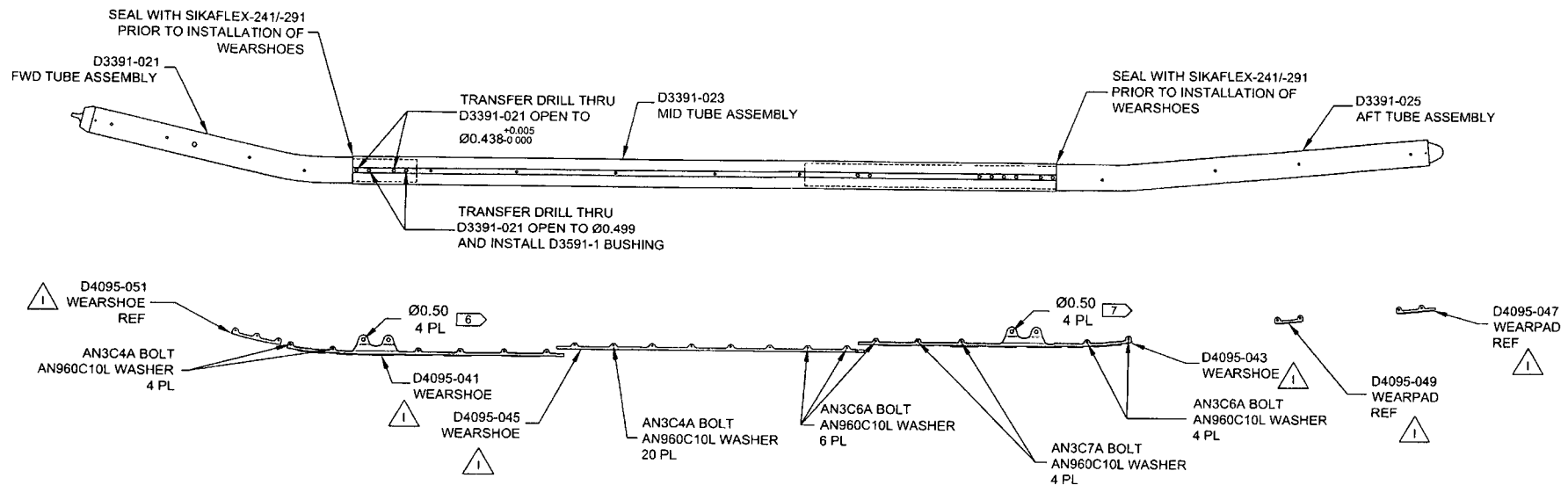
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83866



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-043		
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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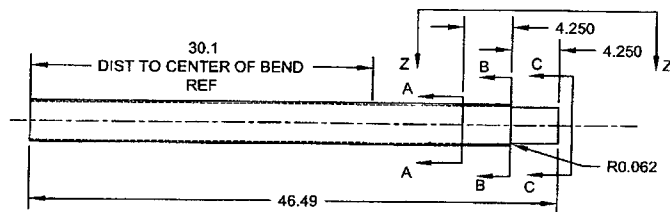
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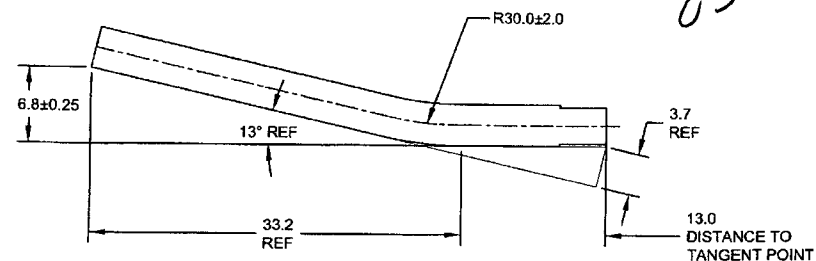
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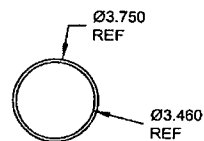
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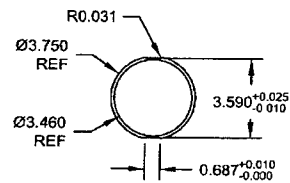
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



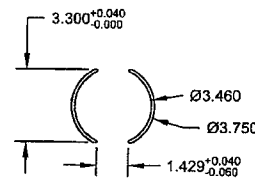
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



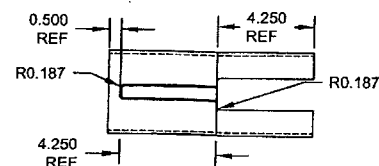
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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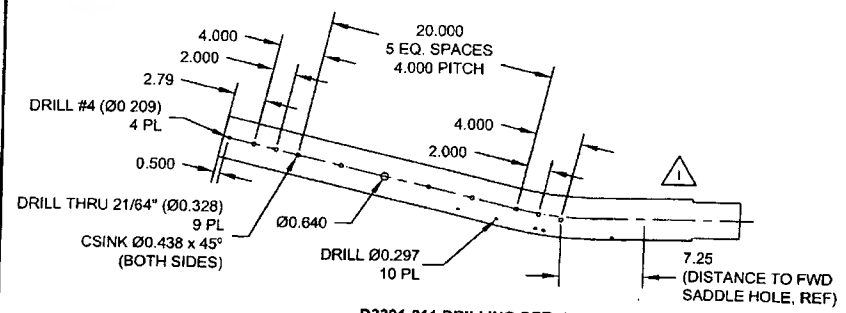
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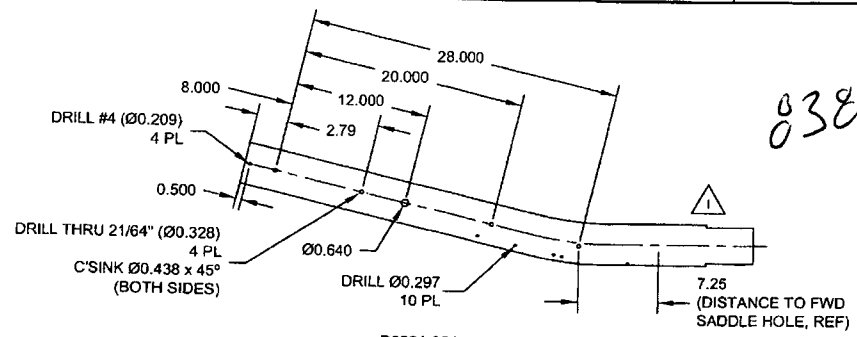
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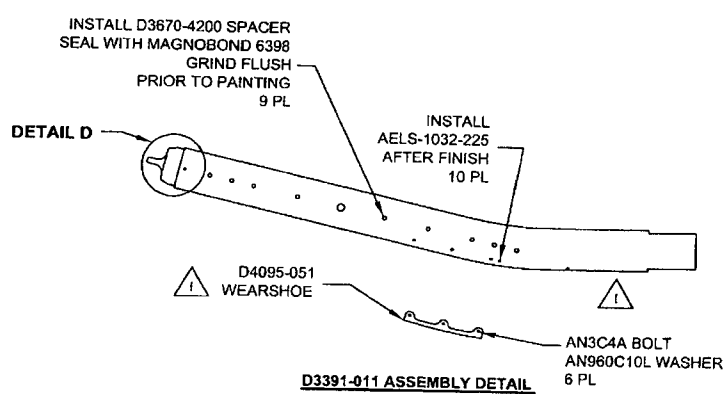
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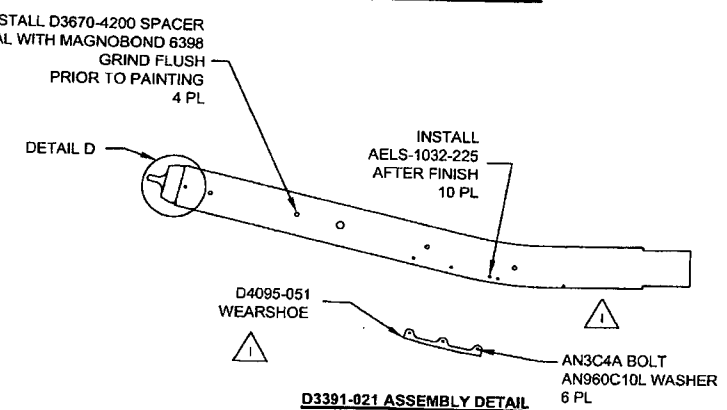
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



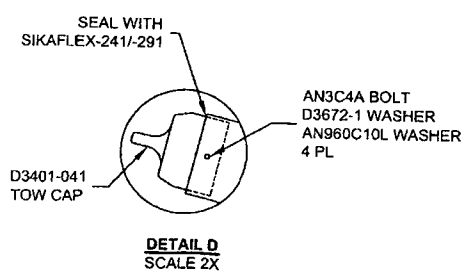
D3391-011 ASSEMBLY DETAIL



D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT



DETAIL D SCALE 2X

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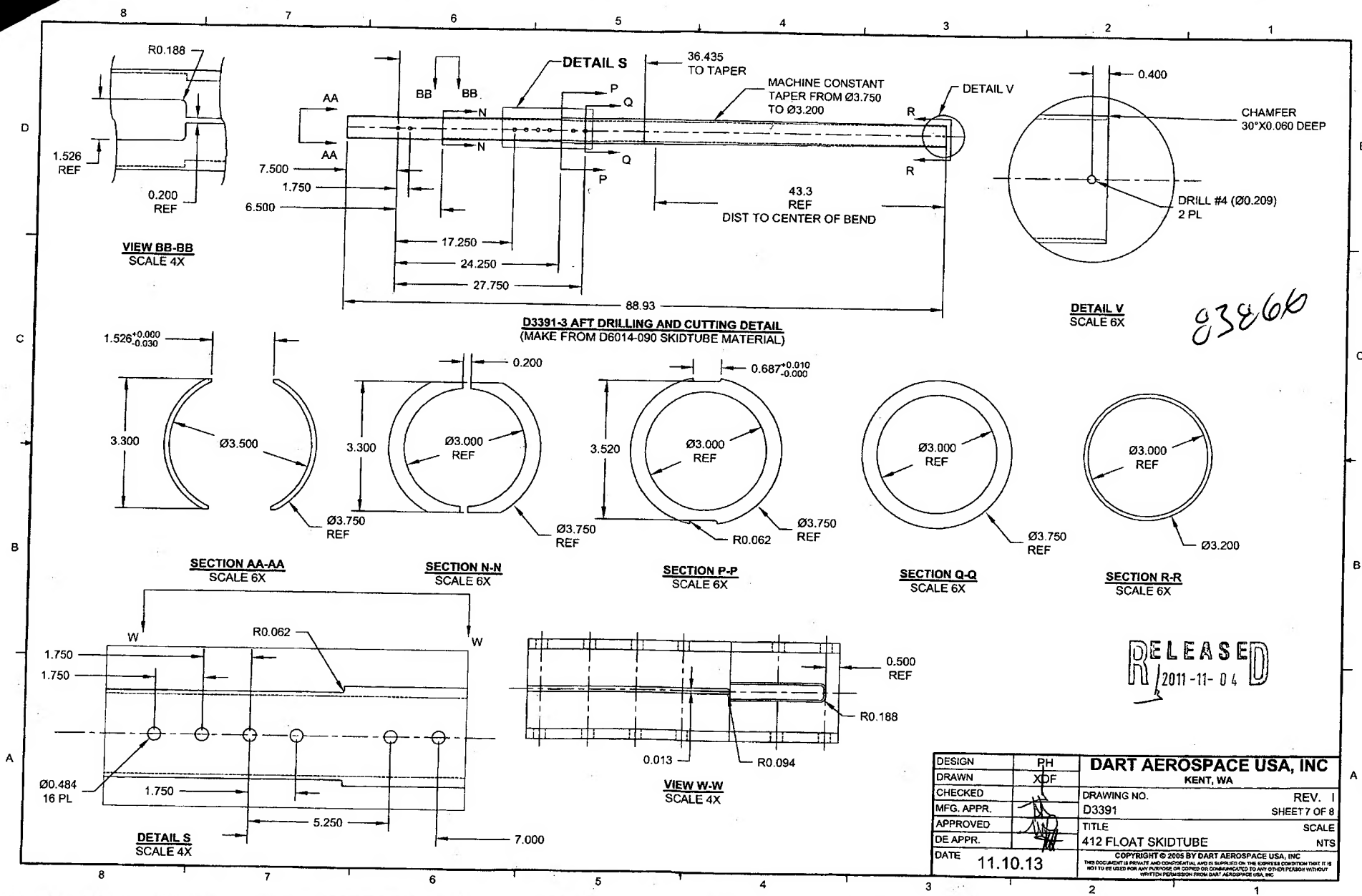
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